

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012813**Date Inspected:** 29-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) OBG L1E/L2E - field splice back gouging
- 2) OBG L2E/L3E - splice welding setup
- 3) Document reviewing

1) The QAI observed ABF personnel using plasma arc torches and grinders to remove the backing bars from the bottom of OBG L1E/L2E plate E field splice. The QAI observed that the plasma arc torch is set onto a semi-automatic track and is in the process of cutting through / gouging off the backing bars. This work was in progress at the end of the work shift. The QAI also noted that the backing bar on plate C field splice has been partially removed at this time.

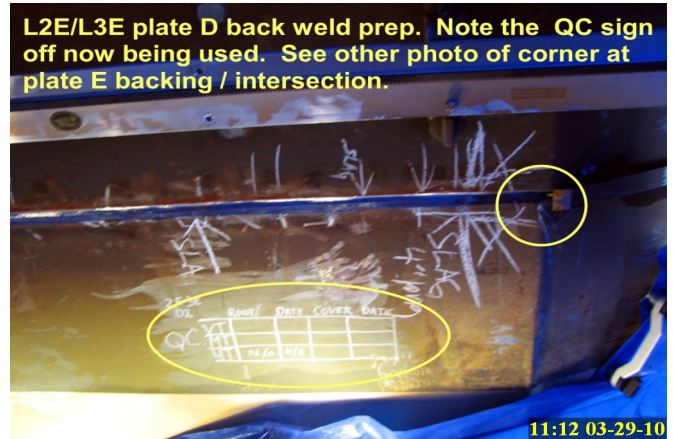
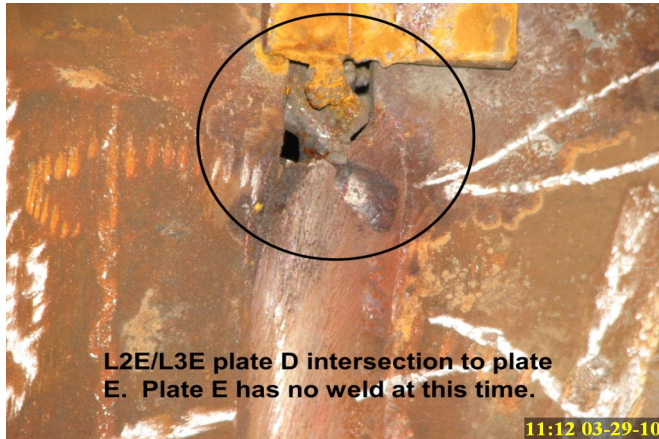
2) The QAI observed ABF personnel setting up equipment to weld at plate C on the interior and plate D exterior at L2E/L3E field splice. The QAI made observations of the fit-up at plate C and noted that the welding will be performed in weld segment C2 from Y location 5278mm to approximately 7800mm. The QAI noted that the fit-up in this area appeared to be conforming to the contract requirements at this time. The QAI measured the root opening between 8mm to 10mm. The QAI was informed by the Quality Control (QC) Inspector Bernie Docena that the fit up of this weld was accepted. The QAI observed that the QC Inspector has made distinguishing marks near the weld to indicate that the fit-up was acceptable. The QAI was informed that they (the QC Inspectors) have

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

been directed to mark all weld locations as observed. The QAI observed that these markings are visible at the plate D exterior (back weld) location and that the back gouged preparation has not been accepted by QC at this time. The QAI also observed that at the corner intersection between plate D and plate E, where D has been back gouged, there is a gap. The QAI is aware that plate E splice weld has not been made yet. See the attached photos.

3) The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI also assisted in reviewing the contractor's submitted welding reports, submittal #01536 Revision 2.



Summary of Conversations:

As noted above, the QAI had general conversations with the QC Inspectors and ABF personnel regarding the work in progress. The QAI was informed that all welds will now have the QC sign-offs written. The QAI relayed the status of work and the status of documentation to the QAI Bill Levell. The QAI also generated a shift turn-over report with this information. There were no other notable observations or conversations during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
